

5/22

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>22972</b>
<b>Description:</b> Blade Fitting LH	<b>Part Number:</b>	<b>D2742-1</b>
<b>Dwg:</b> D2742 Rev. B1; DSK-050 Rev. A; D6103 Rev. A	<b>Qty:</b>	<b>25 23</b>
Page 1 of 1		

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller <b>Dwg not required</b>	PL	05.04.13	25
2	PG	Issue P/O: <u>2007907</u> Material: 7075-T6/T651 (QQ-A-200/11 or QQ-A-225/9) 3.250" OD x 12.500" Long (+0.100/-0.030) per P/N D6103-001 <b>Certificate of Conformity is required</b>	U	05.04.13	25
3	RG	Receive and Inspect for transit damage <b>Ensure Certificate of Conformity is attached</b>	CL	05.04.13	25
4	QC6	Inspect dimensions as per Dwg D6103	U	05.04.26	25
5	<del>MS</del> <del>PL</del>	Machine as per Folio FA099 ( <b>Note: Lathe work only!</b> ) <del>Issue P/O: 2007908 FOR DSK 050</del>	U	05.04.20	25
6	<del>QC2</del> <del>PL</del>	Inspect parts as they come off the CNC machine <del>Receive - Inspect for Damage.</del>	CL	05.04.25	25
7	<del>QC8</del> <del>QC6</del>	Second inspection <b>Dimensional Check.</b>	CL	05.04.25	25
8	MV	Machine as per Folio FA099 ( <b>Note: HAAS work!</b> )	JL	05.06.30	23
9	QC2	Inspect parts as they come off the CNC machine	JL	05.06.30	23
10	QC8	Second inspection	FL	05.06.30	23
11	FP	Chemical Conversion Coat as per QSI 005 4.1	FF	05.07.07	23
12	FP	Powder Coat White (REF 4.3.5.1) as per QSI 005 4.3	FL	05.07.08	23
13	QC3	Inspect Powder Coat	MM	05.07.08	23
14	FP	Install ALS4-1032-225 Insert as per Dwg D2742 Qty Part Number Description Batch 4 \ ALS4-1032-225 Insert <u>m14576</u> or AKS4-1032-225 or ALS7-1032-225 or AKS7-1032-225	FL	05.07.11	23
15	QC5	Inspect part 100% for completeness on the W/O	MM	05.07.11	23
16	FP	Identify and Stock	FL	05.07.11	
17	AC	Cost / part <u>199.84</u>	AP	05/07/15	23
18	DC	Close W/O <u>192.71</u> Inspect Level 21	PL	05/07/12	23

Rev	Date	Change	Revised By	Approved
A	98.09.09	New Issue	DS/CP	
B	98.11.02	Blank size, inspection level added	KS	
C	99.02.02	Changed Procedure, Insert	DM	
D	00.11.01	Removed P/O for Powder Coat & for turning	EC	
E	00.11.17	Added picking DSK-050	EC	
F	02.05.07	Added turning sequence( remove DSK 050 )	NG	
G	02.09.20	Re-format; Added P/O	KJ	
H	04.03.09	Added Steps 3 & 4	KJ/RF	

RELEASED  
04.04.01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05/06/28	8	2 parts placed in vice wrongly 2	<i>[Signature]</i> rester	destrey <i>[Signature]</i> 2	<i>[Signature]</i> 05-07-12	<i>[Signature]</i> 05-06-28 2-05-06-30	<i>[Signature]</i> rester	<i>[Signature]</i> 05-06-28 2-05-06-30

Part No: D2742-1 PAR #: \_\_\_\_\_ Fault Category: Prod/FAB ASS <sup>machined parts</sup> NCR: Yes No DQA: [Signature] Date: 05/07/12

NOTE: Date & initial all entries QA: N/C Closed: [Signature] Date: 05.07.12

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 22972
<b>Description:</b> Blade Fitting		<b>Part Number:</b> D2742-1
<b>Inspection Dwg:</b> D2742 Rev: B1; DSK050 Rev: A		<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
LATHE	8.000	+0.030/-0.000					
	9.250	+/-0.010					
	Ø3.240	+0.005/-0.000					
	Ø3.125	+0.005/-0.000					
	Ø2.780	+0.005/-0.000					
	Ø2.450	+0.005/-0.000					
	0.125 x 45°	+/-0.010					
	0.125	+/-0.010					
	12.50	+0.030/-0.000					
HAAS	0.100 x 0.135	N/A	N/A				
	0.500	+0.005/-0.000	.502	✓		Vern	
	1.500	+/-0.005	1.498	✓		"	
	11.46	+/-0.030	11.480	✓		2-gauge	
	1.180	+/-0.005	1.180	✓		vern	
	3.150	+/-0.005	3.150	✓		vern	
	3.500	+/-0.005	3.499	✓		vern	
	Ø0.484	+0.005/-0.000	.485	✓		vern	
	Ø0.508	+0.005/-0.000	.509	✓		vern	
	1.000	+/-0.010	1.993	✓		vern	
	0.926	+/-0.010	.933	✓		vern	
	0.500	+/-0.010	.504	✓		vern	
	1.230	+/-0.010	1.232	✓		2-gauge	
	0.125	+/-0.010	.128	✓		vern	
	2.620	+/-0.010	2.633	✓		vern	
	0.297	+0.005/-0.000	.298	✓		vern	
	Ø0.430 x 0.045	+/-0.010	.433 x .049	✓		vern	

<b>Measured by:</b> J.L.	<b>Audited by:</b> [Signature]	<b>Prototype Approval:</b> N/A
<b>Date:</b> 05/06/28	<b>Date:</b> 05.06.28	<b>Date:</b> N/A

Rev	Date	Change	Revised by	Approved
A	03.12.12	New Issue	KJ/RF	[Signature]

RELEASED

RF 04.01.15

# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Apr 11, 2005  
07:31 am

Work Order No : 0022972  
Project Name : D2742-1  
Project For : WK522  
Work Order Type : Main  
Main WO Number :  
House Part Number : D2742-1  
Description : Blade Fitting, LH  
Manufactured : Yes  
Amount Req'd : 25  
Amount Done : 0  
Start Date : 04-08-05  
Est Finish Date : 05-30-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

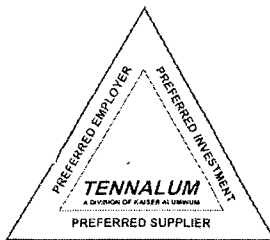
Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Mark Up : 0.000%  
Actual Mark Up : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

# KAISER ALUMINUM FABRICATED PRODUCTS

Tennalum  
PO Box 669  
Jackson, TN 38302  
731-423-2811



**CERTIFIED TEST REPORT**  
<http://KaiserEngProd.com>

CUSTOMER PO NUMBER: CB4007		CUSTOMER PART NUMBER: 024363		PRODUCT DESCRIPTION: Cold Finished Round	
KAISER ORDER NUMBER: 598180	LINE ITEM: 1	SHIP DATE: 02/22/2005	ALLOY: 7075	TEMPER: T651	
WEIGHT SHIPPED: 2181 lbs.	QUANTITY: 18 pcs.	B/L NUMBER: 22784	DIAM/DAF/THKNS: 3.250 in.	WIDTH: 0.000 in.	LENGTH: 144.0 in.
SHIP TO: Copper & Brass Sales, Inc. 381 Osage Dr. Maumee, OH 43537 USA			SOLD TO: Copper & Brass Sales, Inc. Attn: Accounts Payable P. O. Box 5116 Southfield, MI 48086-5116 USA		

Test Code: 1000

## Actual Physical Properties

Lot Number	LONG. UTS ksi	LONG. YTS ksi	LONG. ELONG. %
20062116	80.7	73.4	15.0
20062743	81.0	73.7	14.0

☒ Size  
☐ Part #  
☐ Special Instructions  
☐ Alloy  
☐ Heat/Lot

These test reports are for material shipped on your PO# 2001907  
From TMX Copper & Brass Sales  
Quality Representative

## Chemical Composition, WT. % (Aluminum Remainder)

	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	OTHERS EACH	OTHERS TOTAL
Max	0.40	0.50	2.0	0.30	2.9	0.28	6.1	0.20	0.05	0.15
Min			1.2		2.1	0.18	5.1			

## Specifications

Standard: ISO 9001, ASTM B211-03, AMS 4123G, AMS-QQ-A-225/9

## Miscellaneous Notes

This material was melted and manufactured in the USA. Mercury is not a normal contaminant in aluminum alloys. Neither mercury nor any of its compounds were utilized by Kaiser Aluminum in the manufacture of this material. This material meets the requirements of (cold finished) T6 temper, AMS 4122J and QQ-A-225/9E (CANCELLED).

## CERTIFICATION

Kaiser Aluminum & Chemical Corporation ("Kaiser") hereby certifies that the metal shipped under this order has been inspected and tested and found in conformance with the applicable specifications forming a part of the description set forth in Kaiser's sales acknowledgement form. Any warranty is limited to that shown on Kaiser's general terms and conditions of sale. Test reports are on file, subject to examination.

John Rennekamp, Quality Manager

*John Rennekamp*

Plant Serial: 48340

Kaiser Order Number: 598180